

78170

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 02/01/2012 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 31/01/2012 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: M.L.J Date: 12/01/02 Tooling: Date:

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| | |
|-----------------|---------------------|
| Draw Nbr | Revision Nbr |
| D3560 | Rev D |

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per Folio FA693 Rev: 1/2 & Dwg D3560 Rev: 1/2
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 78170

78170

Page 2

January-02-12 8:13:53 AM

Item ID: D3560-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Weldment
 Start Date: 02/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|-----------------------------------|------|--|----------|--|--|--|--|--|
| 130 | QC8- Inspect parts - second check | 0.00 | | 12-01-17 | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|--------------|-----------|------|--|--|--|---|---|--|--|
| 140 | Large Fab | 0.00 | | | | 3 | 0 | | |
| *140* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | | | | | | | | | |

1-Weld assembly as per dwg D3560
 STEP:
 1- clean material (buff bracket and bottom of arm with blue pad)
 2- set up bracket and arm on jig
 3- preheat bracket and arm with torch
 4- clean before welding with brush
 5- set up machine to 135 amps
 6- weld across bottom and top ends
 7- reheat with torch (65 deg C)
 8- on one side weld from bottom to top half way
 9- same for other side (half way)
 10- from half way point weld the rest of the first side (ease off pedal near end)
 11- same for remaining side (ease off pedal near end)

B# Rod M119712

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 78170

January-02-12 8:13:53 AM

78170

Page 3

Item ID: D3560-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Weldment
 Start Date: 02/01/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------------------------|-----------------------------------------------------------|----------------------|---------|----------|--------------|---------------|---------------|------------------|----------------|
| 150 *150* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | 51210170 | | (43) | | | |
| 160 *160* QC Quality Control | QC9- Inspect visual per QSI004- Fusion Welds Memo | 0.00 0.00 | | | | | | | |
| 170 *170* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | | | | |

* 3 9 BE12-0120

3 12-1-24

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Page 5

January-02-12 8:13:53 AM

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Item Name: Arm Weldment
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Required Date: 31/01/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 210 | Identify as per dwg & Stock Location: <u>WA</u> | 0.00 | | | | | | | |
| *210* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | *** STOCK IN STEP CELL*** | | | | | | | | |
| 220 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *220* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/1/30 *[Signature]*
MF
12-01-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

January-02-12 8:13:57 AM

Page 1

Work Order ID: 78170

78170

Parent Item: D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2808

Manufactured

No

100

Each

22.0000

1

6

D2808

Bushing

**

9/3/12/01/24

Location

Loc Qty

Loc Code

GA

22

32896

2

71879

8

76188

12

3

M6061T6B0.500X05.00
0

Purchased

No

140

f

38.4750

1.395

8.810526

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

aur 12/01/09

Location

Loc Qty

Loc Code

MAT001

38.475

112154

6.935

117933

7.54

~~119324~~

24

M119346 X 4.39

D3592-1

Manufactured

No

190

Each

9.0000

1

6

D3592-1

Plate

**

12.01.19

Location

Loc Qty

Loc Code

WA002

9

47015

2

48517

7

3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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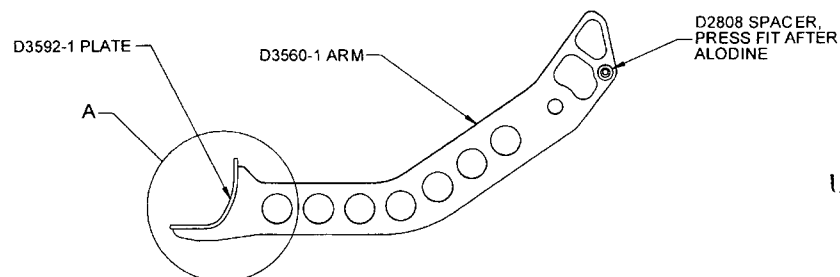
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

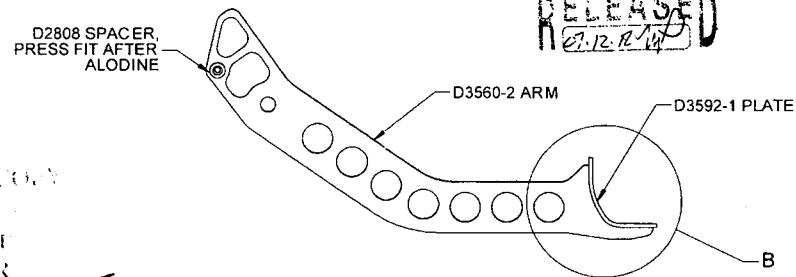
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NOTE: Date & initial all entries

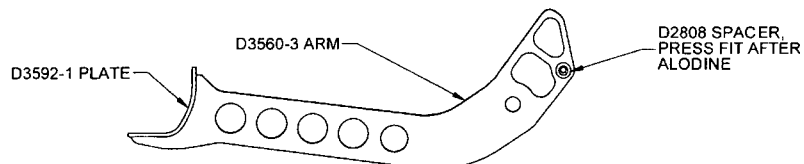
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27.12.14



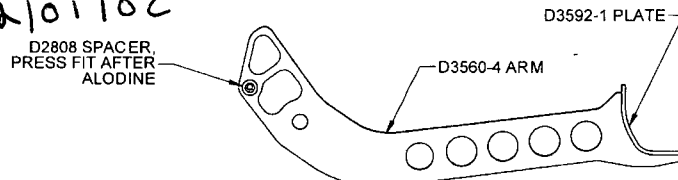
D3560-041 ARM WELDMENT



D3560-042 ARM WELDMENT

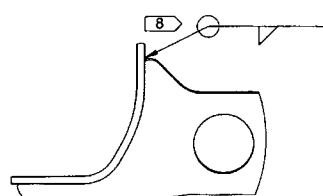


D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT

SHOW ONLY
RETURN TO
ORIGINAL
UNCONTROLLED COPY
SUBJECT TO ALL
NOTES
NO 78170 M.L.J
12/01/02



**DETAIL A
SCALE 1:2**

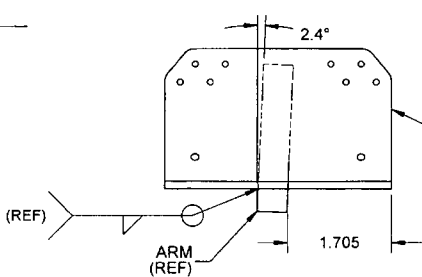
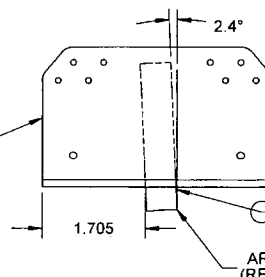
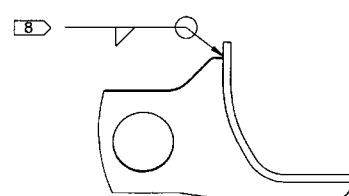


PLATE
(REF)



ARM
(REF)



**DETAIL B
SCALE 1:2**

PARTS LIST

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | P/N | DESCRIPTION |
|-------------|-------------|-------------|-------------|-----------|--------------|
| X | | | | D3560-041 | ARM WELDMENT |
| | X | | | D3560-042 | ARM WELDMENT |
| | | X | | D3560-043 | ARM WELDMENT |
| | | | X | D3560-044 | ARM WELDMENT |
| 1 | 1 | 1 | 1 | D2808 | SPACER |
| 1 | | | | D3560-1 | ARM |
| | 1 | | | D3560-2 | ARM |
| | | 1 | | D3560-3 | ARM |
| | | | 1 | D3560-4 | ARM |
| 1 | 1 | 1 | 1 | D3592-1 | PLATE |

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.23 lbs (TYP)
 8) WELDING: PER DART QSI 004

| | | | |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------|----|----------|
| D | ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS | DC | 07.11.16 |
| C | REMOVE POWDER COAT | CP | 07.06.19 |
| B | REDESIGN AS WELDMENT, ADD POCKETS | CP | 07.01.15 |
| A | NEW ISSUE | CP | 06.09.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.11.16 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3560 TITLE ARM WELDMENT SCALE 1:4 REV. D SHEET 1 OF 5 COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

7.65
5.631
4.479
2.463
0.210
0.000

PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW C-C

C
R0.030
R0.030
0.000
0.79
1.37
2.117
2.86
3.426
4.801
6.176
7.00
7.546
8.769
9.902
11.035
12.682
14.357
14.73

R0.30 (TYP ALL OUTSIDE CORNERS EXCEPT WHERE INDICATED)
R0.49
R0.75
0.188
0.250
0.275
C'BORE $\varnothing 0.507^{+0.000}_{-0.001}$
0.250 DEEP FROM THIS SIDE
R0.35 (TYP)
R0.40
R0.375
3.66
1.700
0.850
1.000
2.000

0.000
0.79
1.37
2.117
2.86
3.426
4.801
6.176
7.00
7.546
8.769
9.902
11.035
12.682
14.357
14.73

R0.13 (TYP) (POCKETING RAD)
R4.00
0.188
0.500
R0.032 AT BASE OF C'BORE
34.5°
R2.00
 $\varnothing 1.000$ THRU (TYP 7 PLACES)
 $\varnothing 0.507^{+0.000}_{-0.001}$
R1.00
17.9°
R0.30
R2.00
19.7°
 $\varnothing 0.196$ (DRILL #9 REF)
C'SINK $\varnothing 0.385 \times 100^\circ$
R0.30
50.0°

0.375
2.4°
VIEW C-C
SCALE 1 : 1

RELEASED
2012.11.16

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

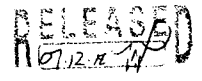
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO.
D3560
TITLE
ARM WELDMENT
SCALE
1:2
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NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
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7.11.16

8 7 6 5 4 3 2 1

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



| | | | |
|----------------------|-----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | <i>JP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3560 TITLE ARM WELDMENT COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMPARED TO ANY OTHER PERSON'S WORK WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | REV. D |
| DRAWN | <i>JC</i> | | SHEET 2 OF 5 |
| CHECKED | <i>JS</i> | | SCALE |
| MFG. APPR. | <i>JS</i> | | 1:2 |
| APPROVED | <i>MD</i> | | |
| DE APPR. | <i>JS</i> | | |
| DATE 07.11.16 | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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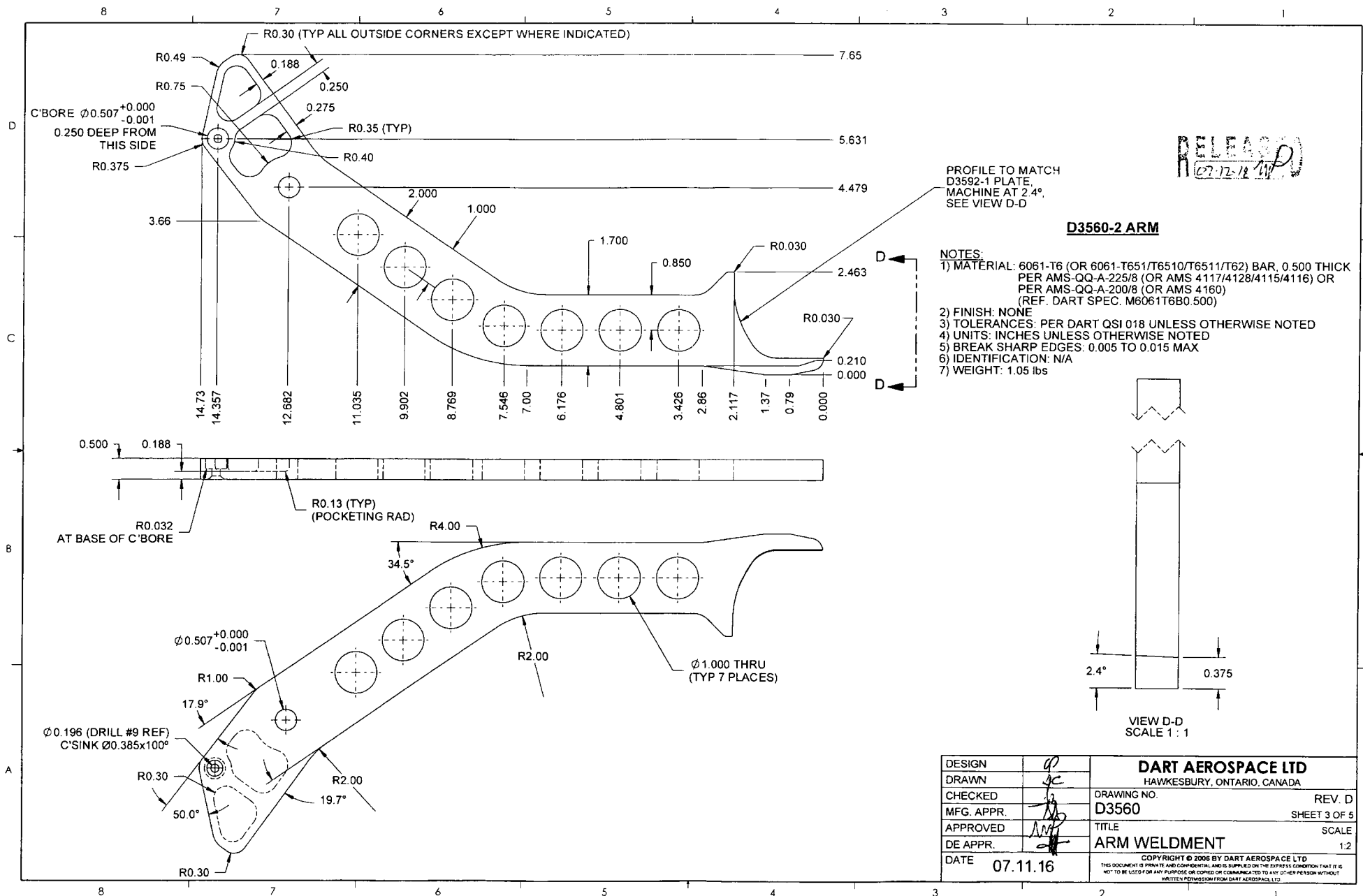
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NOTE: Date & initial all entries

78170



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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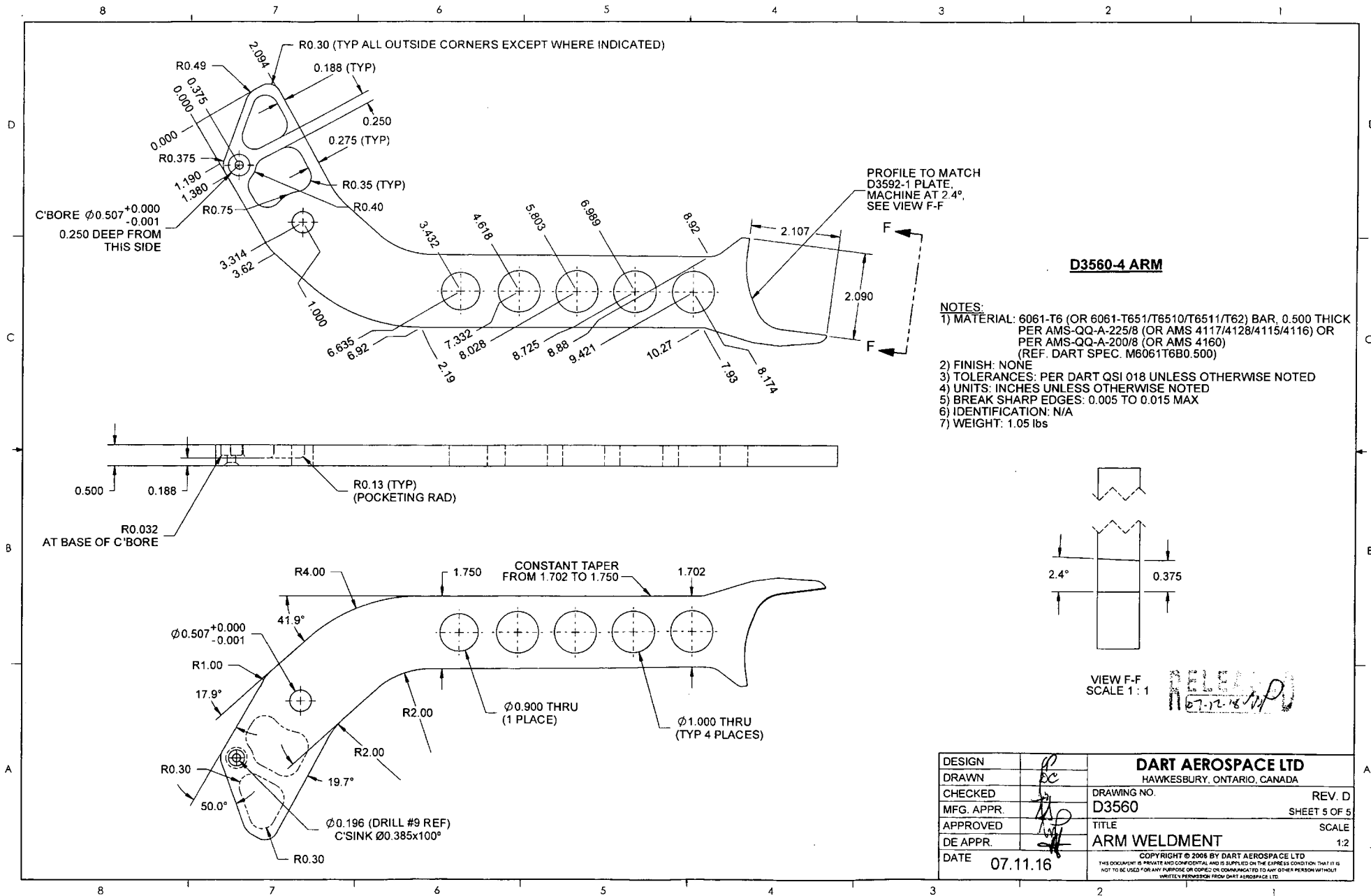
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|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: Arm | | Part Number: | D3560-1 |
| Inspection Dwg: D3560 | Rev: D | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| Ø0.507 | +0.000/-0.001 | .5065 | / | | | |
| Ø0.196 | +0.005/-0.001 | .195 | / | | | |
| Ø1.000 | +0.010/-0.001 | 1.004 | / | | | |
| 0.500 | +/-0.010 | .495 | / | | | |
| 0.250 | +/-0.010 | .255 | / | | | |
| 0.275 | +/-0.010 | .273 | / | | | |
| 0.188 | +/-0.010 | .187 | / | | | |
| 2.000 | +/-0.010 | 1.999 | / | | | |
| 1.700 | +/-0.010 | 1.699 | / | | | |
| Ø0.385 x 100° | +/-0.010 x 0.5° | .385 | / | | | |
| 0.250 Deep | +/-0.010 | .245 | / | | | |
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|------------------------|-----------------------|----------------------------|-----|
| Measured by: RQ | Audited by: S | Prototype Approval: | N/A |
| Date: 12-1-12 | Date: 12-01-17 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 07.01.17 | New Issue P/O D3560-041 | KJ/JLM | |
| B | 07.06.13 | Dimensions updated per Dwg Rev B | KJ/JLM | |
| C | 08.07.24 | Dwg Rev updated | KJ/DD | |